

Work Order ID 118969

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118969

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Item ID: D3246-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 5/05/14

Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

DeburrForm as per Dwg D3246C'sink as per Dwg D3246

12

14/06/26

DAS
36
9-89

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

DAS
27
9-89
MTH

12

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

12

7614-7-8

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Item ID: D3246-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 5/05/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo 4x PPP 121987	0.00				12x		DAS 28	JUL 09 2014
Packaging	4x PPP 121989							9-89	
	4x PPP 121988								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MLJ 14-07-09

14-7-9

Picklist Print

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Work Order ID: 118969

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Parent Item: D3246-041

D3246-041

Parent Item Name: Bracket

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050		Purchased	No			170	sf	136.6911	0.3097	85			DAS 23 9-89
M2024T3S 050									**				14-06-26
2024-T3 .050 sheet													

Location	Loc Qty	Loc Code
MAT022	136.6911	
124643	53.7911	
m128354	48	
m128713	34.9	

MS20426AD3-3		Purchased	No			170	Each	5,595.000	8	64			DAS 36 9-89
MS20426AD3-3									**			14/07/08	
RIVET													

Location	Loc Qty	Loc Code
ST334	344	
123352	344	
ST553	5251	
M128754	5251	

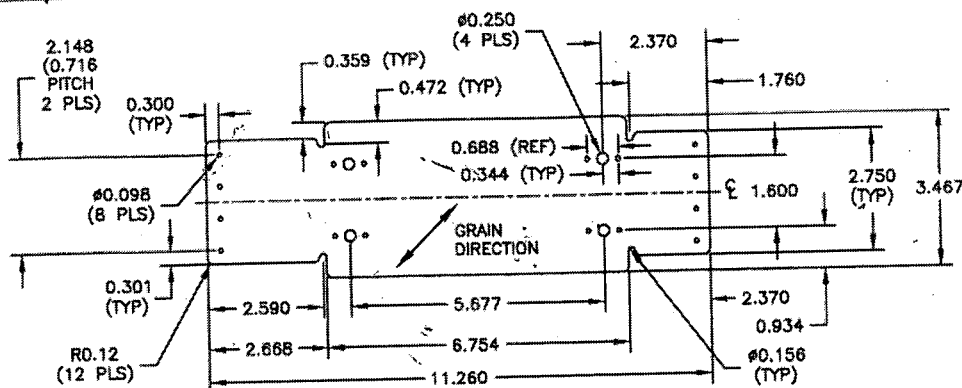
MS21059L3		Purchased	No			110	Each	331.0000	4	32			DAS 36 9-89
MS21059L 3									**			14/07/08	
Nut Plate													

Location	Loc Qty	Loc Code
ST305	331	
114449	4	
M127743	2	
M128300	58	
M128936	67	
M128976	100	
M129472	100	

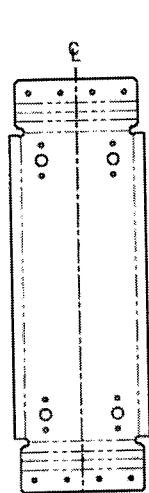


DESIGN #	DRAWN BY KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21	TITLE MOUNTING BRACKET		SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C'SINK	

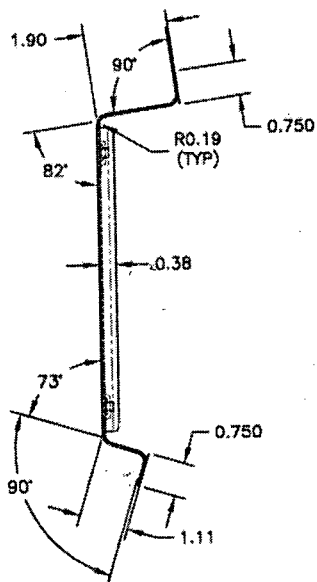
RELEASED
04.05.07



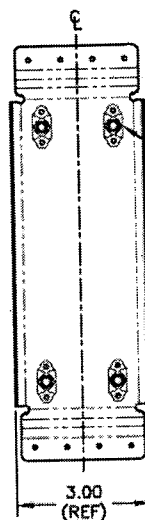
D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY



MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK Ø0.185 x 100°
MS20426AD3-3 RIVET (2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 118969 MJS
14-05-07

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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